



- NOTES:
1. THIS IS A ULTRA HIGH VACUUM ASSEMBLY. ELECTROPOLISHING IS NEEDED BEFORE WELDING. PRIOR TO ELECTROPOLISHING, THE PARTS NEEDS TO GO THROUGH A MULTIPLE STEP CLEANING PROCESS INVOLVING DEGREASING, WASHING AND DRY NITROGEN BLOW DOWN.
 2. WELDMENT ASSEMBLY SHALL BE LEAK TESTED USING A MASS SPECTROMETER WITH MINIMUM SENSITIVITY FOR HELIUM OF 2 X 10⁻¹⁰ STANDARD CCSCC PER LEAK METER DIVISION, SUCH AS:
ALCATEL SAM-110TCL
DU PONT CSC-24-125B
VARIAN MS-8, MS-90 OR MS-18
CALIBRATION OF THE LEAK DETECTOR SENSITIVITY SHALL BE PERFORMED JUST PRIOR TO TESTING.
FINAL TEST WILL CONSIST OF SURROUNDING THE ASSEMBLY (BAGGING) WITH HELIUM. THE ASSEMBLY WILL BE REJECTED IF A 2% DEFLECTION ON THE MOST SENSITIVE RANGE OF THE LEAK DETECTOR IS SENSED WITHIN 1 MIN.
 3. ASSEMBLY SHALL BE WATER TESTED FOR LEAKS @ 300P.S.I.
 4. KEEP THE ASSEMBLY CLEAN, AND WRAP FOR UHV PACKING WITH ALUMINUM FOIL.
 5. DIMENSIONS IN [] ARE MILLIMETERS AND FOR REF. ONLY

REF. SOURCE

- (SWAGelok)
DEARBORN VALVE & FITTING CO.
1540 N. OLD RAND ROAD
P.O. BOX 847
WALUCONDA, IL 60084-0847
708-526-6900
FAX: 708-526-1221
- THE LEE CO.
2 PETERAUX RD.
WESTBROOK, CN 06498-0424
203-399-6281
FAX: 203-399-7058

1	ITEM 7 & 8 CHANGED:	J.G.	J.C.	12/20/94
2	ITEM 4 WAS QTY 4 GEN. UPDATE:	J.G.	J.C.	12/20/94
3	REVISIONS	REV	DATE	DATE

9	PLGA000020A	LEE PLUS	SST	5
8	SS-600-7-2	3/8" TUBE FEMALE CONNECTOR	SST	2
7	SS-24LN-1.50	1/8" NPT HEX. NIPPLE x 1.50 LG	SST	2
6	PA105090905-230006	PS RIGHT VACUUM FLANGE	SST	1
5	PA105090905-230006	PS LEFT VACUUM FLANGE	SST	1
4	PA105090905-230004	PS 4.5" O.D. EXTENSION TUBE	SST	1
3	PA105090905-230003	PS RECTANGULAR EXTENSION TUBE	SST	1
2	PA105090905-230002	PS 8" COPPER WELD	COPPER/SST	4
1	PA105090905-230001	PS MAIN BODY	GLD - COP	1

ITEM	QUANTITY	DESCRIPTION	REWORK/REPAIR OR DESCRIPTION	REWORK/REPAIR	QTY
A1858601					
ARGONNE NATIONAL LABORATORY					
ADVANCED PHOTON SOURCE					
PS I.D. FIXED WHITE BEAM STOP ASSEMBLY					
P4105090905-230000-01					